

Work Order ID 131120

131120

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March-26-15 1:43:20 PM

Item ID: D119-796-151 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Crosstube, STD w/ Peg Steps (MKII)
 Start Date: 3/26/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 1503-31 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D119-796-151	D

120	Pick Kit	0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging									

130	Crosstubes	0.00							
130									
Crosstubes	Memo	0.00							
Crosstubes	1- Install step and clamp with the proper position per dwg D119-796-151								
	Torque all clamps to 50 IN-LBS max.								

140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control	***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***								

DAS
38
9-89
JUN 09 2015

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00							
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-796-151								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

USED ON
W/O B133164

① SAG 15/06/09

MLJ JUN 09 2015

MLJ JUN 09 2015

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March-26-15 1:43:19 PM

131120

D119-796-151

Required Date: 3/26/15

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:C
14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV :D 15-02-11
AS PER REV D JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-141		Manufactured	No				Each	0.0000		1			
D119-796-141													
Fwd Crosstube, STD w/o Peg Steps (MKII)						B 131547			**				CN 15-05-29
D5123-3		Manufactured	No				Each	50.0000		4			
D5123-3													
Clamp Cushion									**				CN 15-05-29
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>		4			
				Ig55			50						
				126747			44						
				127133			6						
D5149-041		Manufactured	No				Each	0.0000		2			
D5149-041													
Fwd Step Base Assembly						SF114 · 131331			**		2		CN 15-02-29
MS21920-22		Purchased	No				Each	53.0000		4			
MS21920-22													
Clamp									**				CN 15-02-29
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				LG050			53						
				M128636			3						
				M120822			50						
				M132045						4			

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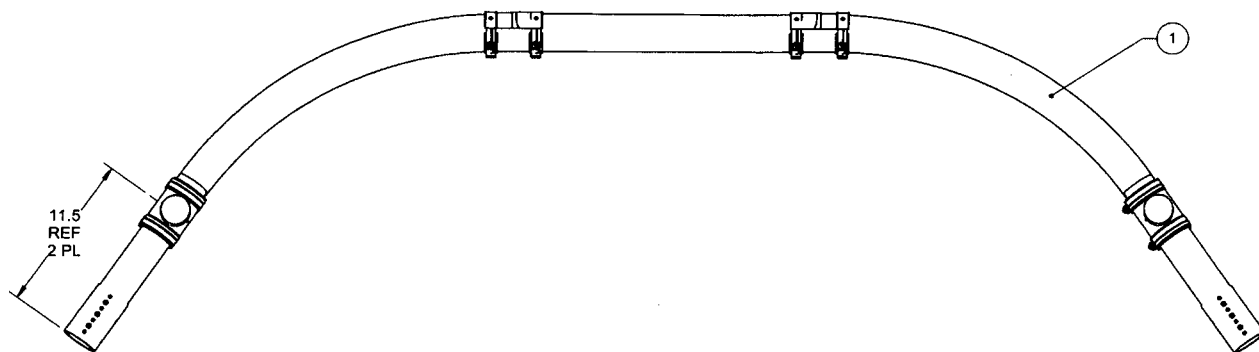
ITEM	QTY	P/N	DESCRIPTION
	151		
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP

△

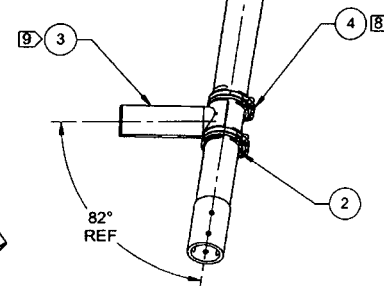
△

131120 MLC
15-03-31

D119-796-141 XTUBE
BENDING PLANE



D119-796-151 XTUBE ASSY (AW119 MKII FWD)



RELEASED

2015 FEB 09

ECN 15-516 9

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 19.87 lbs
- 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

△

D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION, MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, AN4C6A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.08.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	JLM	D119-796-151	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
DATE	15.01.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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